

Claims.

1. A blow head assembly for an I.S. machine for  
blowing a parison of glass in a blow mold and cooling the  
5 blown parison into a formed bottle which can be removed  
from the blow mold comprising  
a blow head arm,  
at least one blow head supported by said blow  
head arm,  
10 each of said blow heads including an inlet for  
supplying air to the interior of a parison,  
displacement means  
for lowering said blow head arm from a  
retracted position to an "on" position whereat the blow  
15 head engages the top surface of a blow mold,  
for raising said blow head arm, at a  
predetermined time after the blow head engages the top  
surface of the blow mold a selected vertical distance  
above the top surface of the blow mold from said "on"  
20 position to an exhaust position to allow air to escape  
from the blow mold,  
said selected vertical distance being  
selected so that at least a minimum pressure will  
continue within the formed bottle, and  
25 for maintaining said blow head at said  
exhaust position for a predetermined time and then  
raising said blow head to the retracted position.

2. A blow head assembly according to claim 1,  
30 further comprising input means for inputting said  
selected vertical distance.

3. A blow head assembly according to claim 1,  
further comprising input means for inputting said  
35 predetermined time.

4. A blow head assembly according to claim 3,  
wherein said pressure setting means further comprises  
means for determining when the parison has been blown and  
wherein said predetermined time is the time when the  
5 parison has been blown.

5. A method of blowing a parison of glass and  
forming the blown parison into a bottle in a blow mold of  
an I.S. machine comprising

- 10 a. providing a parison of glass in a blow mold,  
b. engaging a blow head with the blow mold,  
c. providing air under pressure through the blow  
head into the parison to blow the parison,  
d. detecting the point where the parison is blown,  
15 e. lifting the blow head on said detection to  
provide an exhaust for air while continuing to  
supply air through the blow head into the  
parison until the blown parison is cooled to  
the point where a formed bottle can be removed  
20 from the molds.